

Date: Tuesday, 19/08/2008 11:19:33 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 41386
 Estimate Number : 10528
 P.O. Number :
 This Issue : 19/08/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : CROSSTUBES
 Previous Run : 41043
 Drawing Name : 407 HIGH AFT X-TUBE ASSEMBLY
 Part Number : D407667205
 Drawing Number : D407-667-245 U/R
 Project Number : N/A
 Drawing Revision : E 08/08/20
 Material : F 08.11.17
 Due Date : 26/08/2008 Qty: 1 Um: Each

Written By

Checked & Approved By

Comment

Est Rev:C 05.09.02 Add holes for compatibility with Bell
 Skidtubes KJ/JLM
 Est Rev:D Added Magnobond, Rubber Cushion & Clamps
 07-02-19 JLM

****CHANGE TO CHG 005 - IF USING D2894-1 B35578 OR
 GREATER****

Est Rev:E 08-05-22 add comment in seq. 6 and QC15 and
 QC5 DD verified by:EC
 Est Rev:F 08-06-12 add comment in seq. 24 DD verified
 by:EC

Additional Product

Job Number:

Seq. #:

Machine Or Operation:

Description:

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D407-667-205 CHG004

2.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

3.0

D407667205TRN

Crosstube Turning Detail



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

CROSSTUBE TURNING DETAIL

batch B39856

4.0

BENDING

BENDING MACHINE - SKIDTUBES



Comment: LANDING GEAR RESOURCE 1

1-Bend tube as per Dwg D407-667-245 using CNC bender program 407 Aft and Folio FT

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 HIGH AFT X-TUBE ASSEMBLY

Job Number: 41386

Part Number: D407667205

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC15

DIMENSIONAL CHECK OF X-TUBES



08-11-06 ①



Comment: DIMENSIONAL CHECK OF X-TUBES

6.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

P70

1-Drill pilot holes in tube using drill Jig DT8583 & DT8584 as per Dwg D407-667-245. Drill all (3) top holes.

2-Drill and Ream all holes in tube to finish size using drill Jig DT8583 & DT8584 as per Dwg D407-667-245. Check dimensions between holes on all four sides.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8583 & DT8584 as per Dwg D407-667-245. Drill only the top (2) holes.

5-Drill & ream the top (2) holes to finish size using drill Jig DT8583 & DT8584 as per Dwg D407-667-245

6-Drill Aft rivet holes using drill Jig DT8789 as per Dwg D407-667-245. Note: Aft side has 3x top holes.

7-Drill Fwd rivet holes using drill Jig DT8789 as per Dwg D407-667-245. Drill only the top (3) holes.

8-C'sink holes as per Dwg D407-667-245. Allow rivet to sit below surface to compensate for paint.

9-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D407-667-245

10- Scribe tube to identify on the inner chamfer in the cuff D# and B#

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



MB 08-11-7



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



08-11-07 ①



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

QC5

INSPECT WORK TO CURRENT STEP



08-11-07 ①



Comment: INSPECT WORK TO CURRENT STEP

MB
08-11-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D407-667-205 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: NA Date: 08-11-21

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>41386</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08-11-06</u>	<u>4.0</u>	Tube is slightly low on the height, but even. R.C. Had to use old bench.	<u>[Signature]</u> 08/11/06	drill the cuff holes at 0.61" to raise the tube at ass'y, and bring to nominal height.	<u>NVB</u> <u>08-11-7</u> <u>[Signature]</u>	<u>[Signature]</u> 08-11-07	<u>[Signature]</u> per 08/11/06	<u>[Signature]</u> 08-11-06

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 HIGH AFT X-TUBE ASSEMBLY

Job Number: 41386

Part Number: D407667205

Job Number:



Seq. #: Machine Or Operation: Description :

10.0 OUTSIDE SERVICE OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES :
Liquid Penetrant Inspection as per QSI 038Or
Issue P/O: 7542 LPI as per ASTM 1417
Level 2 Attach copy of NDT results to work order

0208/11/10 (1)

11.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Inspect for transit damage
Ensure copy of NDT results attached to work order.

P. 8/11/7 (1)

12.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-11-13 (1)

(PTC)

13.0 SPRAY PAINTING SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

ml 08 11 13 (1)

14.0 QC14 INSPECT SPRAY PAINT



Comment: Inspect Spray Paint
Wrap in plastic bag to protect from scratches

RT 08-11-14

15.0 D2856400 Abrasion Strip



Comment: Qty.: 1.3524 f(s)/Unit Total: 1.3524 f(s)
Pick:

Qty Part number Description Batch
2 D2856-400(Cut to 7.73") Abrasion Strip

37667

RT 08-11-17

16.0 D2873043 Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
Pick:

Qty Part number Description Batch
2 D2873-043 Nut Plate

40218




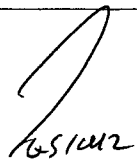
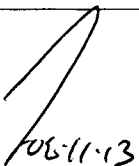
RT 08-11-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

See NCR-08-114

Part No: D407-667-205 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: NA Date: 08.11.21

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>41386</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-11-13	120	The incorrect NDT results were attached to the W/O's. R.C: Part NDT result copy was used as a reference & was included in the new results, submitted to Dart.		See NCR 08-114 attach the correct NDT results.	 08.11.13	 08.11.13	 08.11.13	 08.11.13

NOTE: Date & initial all entries

Date: Tuesday, 19/08/2008 11:19:33 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 HIGH AFT X-TUBE ASSEMBLY

Job Number: 41386

Part Number: D407667205

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

D2873045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-045

Nut Plate

38316 x1 / 41987 x1

RT 08-11-12

18.0

D28941

2.750 Support



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D2894-1

Support

21475

RT 08-11-14

19.0

D31901

Chafing Shield



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D3190-1

Chafing Shield

37969

RT 08-11-17

20.0

D3595

Rubber Cushion (per sq ft)



Comment: Qty.: 0.0246 sf(s)/Unit Total: 0.0246 sf(s)

Rubber Cushion

2X .750" X 4.30"

Batch:

03595-063-450 341108

RT 08-11-14 OKAY TO USE
-450 per 08-11-17

21.0

MS20601AD4W8

RIVET



Comment: Qty.: 14.0000 Each(s)/Unit Total: 14.0000 Each(s)

Pick:

Qty Part number Description Batch

14 MS20601AD4W8 Rivet

106521 x7 / 109297 x7

RT 08-11-12

22.0

MS2192022

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-22

Clamp

107358

RT 08-11-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 HIGH AFT X-TUBE ASSEMBLY

Job Number: 41386

Part Number: D407667205

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

MS2192025

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Clamp(per MIL-DTL-8783C)

Batch: 108 976

85 08-11-14

24.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8674. Install chafing shield as per Dwg D407-667-245. Note:
(3) top holes should be facing up.

2- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe

3-Install support with magnobond and install clamps as per Dwg D407-667-245 using installation jig DT9025.

Torque clamps to 80-100 in lb

A/R Magnobond

Batch: 108 966

EXP: 09-04-01

4-Install nut plates as per Dwg D407-667-245. Touch-up rivet heads with Imron paint.

85 08-11-12

85 08-11-17

85 08-11-14

25.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/11/17

26.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

27.0

AN534A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M109061

8/11/17

80

D407 667 205 B 41386

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 HIGH AFT X-TUBE ASSEMBLY

Job Number: 41386

Part Number: D407667205

Job Number:



Seq. #:	Machine Or Operation:	Description :
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28.0	MS21042L5	Nut
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)
Nut
Batch: M108827

29.0	AN510A	Bolt
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Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)
Pick:Packing Kit
Qty Part number Description Batch
10 AN5-10A Bolt M109282

30.0	AN532A	Bolt
------	--------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)
Pick:Packing Kit
Qty Part number Description Batch
4 AN5-32A Bolt M109068

31.0	AN960JD516	Washer
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Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)
Pick:Packing Kit
Qty Part number Description Batch
18 AN960JD516 Washer M109282

32.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
------	-----	------------------------------------



Comment: INSPECT 100% KITS FOR COMPLETENESS

33.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Identify and in kanban rack
Location: 53

34.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

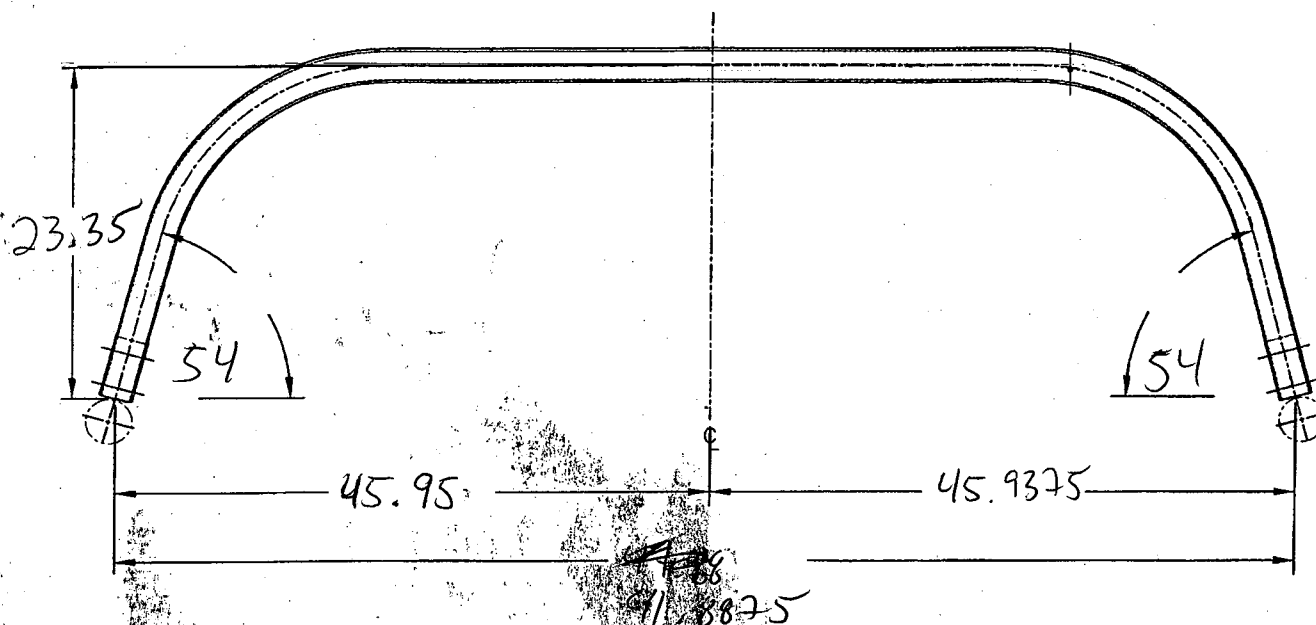
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 41380
Description: Crosstube High Aft: (407)		Part Number: D407-667-205
Inspection Dwg: D407-667-245	Rev: D	Page 1 of 1

Required Dimension	Min	Max
Height	23.46	23.58
1/2 Span	45.86	45.98
Angle	54	56
Total Span	91.72	91.96

23.52.



Comments
Drill cuffs @ 0.61

QC15 Inspection	ASIM2
Date	06.11.06

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	[Signature]

Item	QTY -245	PART NUMBER	DESCRIPTION
1	X	D407-667-245	CROSSTUBE ASSEMBLY (407 HIGH AFT)
2	1	D6011-115	CROSSTUBE
3	2	D2856-400-773	ABRASION STRIP
4	2	D2873-043	NUT PLATE
5	2	D2873-045	NUT PLATE
6	1	D2894-1	SUPPORT
7	2	D3190-1	CHAFING SHIELD
8	2	D3595-063-430	RUBBER CUSHION
9	14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
10	4	MS21920-22	CLAMP
11	2	MS21920-25	CLAMP (OR MS21920-24)
12	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947- 100, TYPE II, CLASS 2 ADHESIVE)

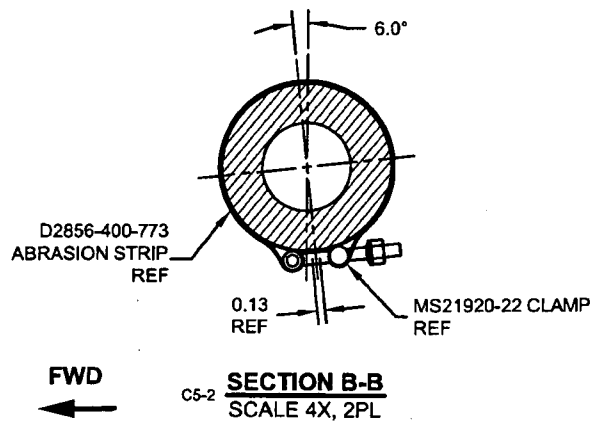
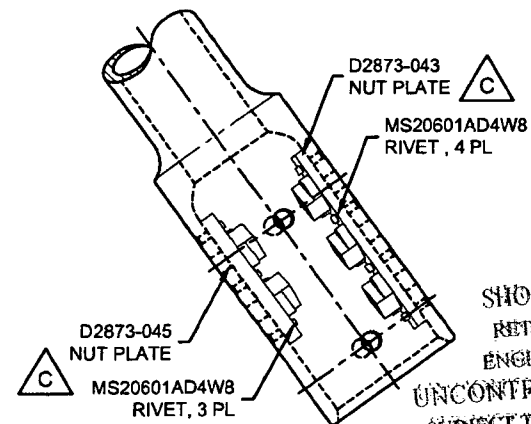
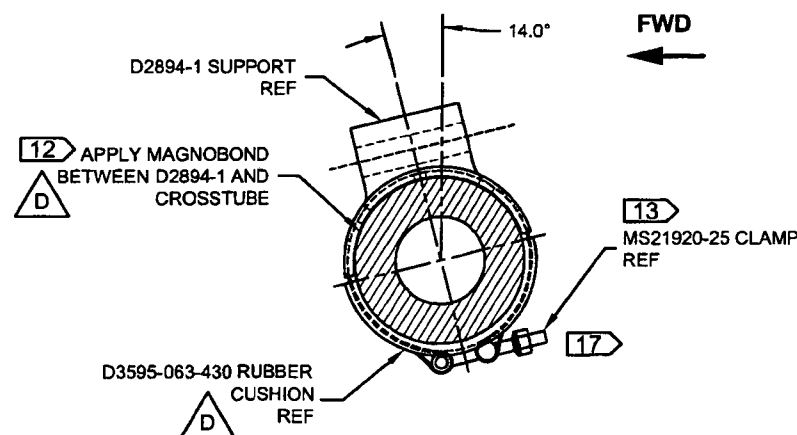
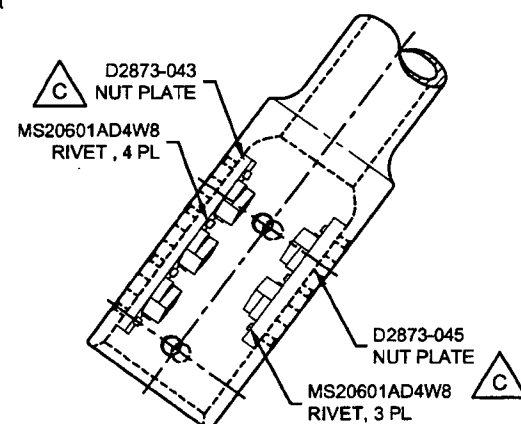
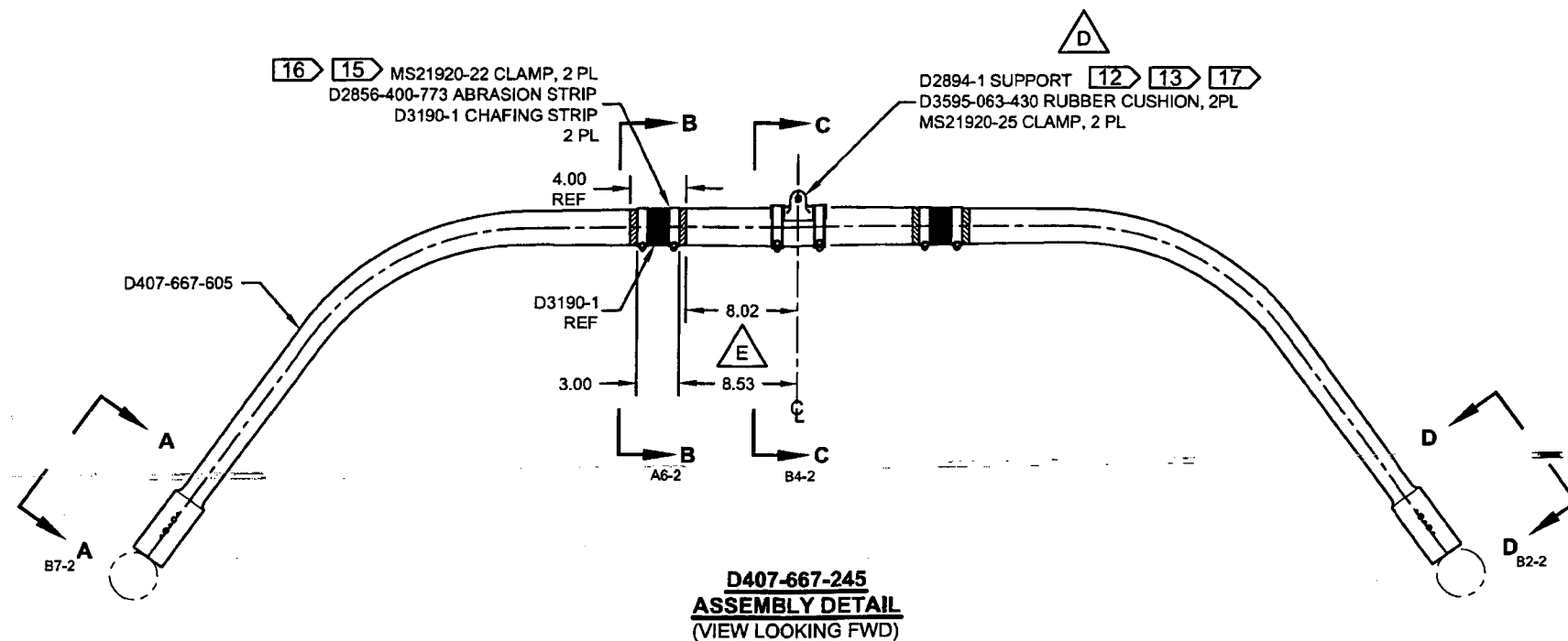
GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6011-115
FINISHED LENGTH = 112.91±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D407-667-245" AND BATCH NUMBER ON
INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 27.7 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 6 PASSES. MAXIMUM TUBE FLATTENING DUE TO
BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2894-1 CENTER SUPPORT USING A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND
6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO
PACKAGING.
- 13) INSTALL MS21920-25 CLAMPS WITH D3595-063-430 RUBBER CUSHIONS TO SECURE D2894-1
SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE CROSSTUBE
SUPPORT.
NOTE: MS21920-24 CLAMPS CAN BE USED TO ACCOMMODATE VARYING DIAMETERS.
ENSURE THERE IS A MINIMUM OF 1.5 THREADS IN SAFETY ON THE NUTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) INSTALL D2856-400-773 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF
CROSSTUBE, PER QSI 035.
- 16) INSTALL D3190-1 CHAFING SHIELDS SO THAT OVERLAP IS ON BOTTOM SIDE OF CROSSTUBE
OPPOSITE D2894-1 SUPPORT.
- 17) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN
SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

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WITHOUT NOTICE
WORK ORDER
NO. 41380

RELEASED
08/11/12 N/A

F	REFORMAT NOTES TO NEW STANDARDS (ZN B8-1); RELOCATED FLAG # 6 (ZN A8-3) PER NCR 210; REMOVED REF. & ADD TOLERANCES (ZN C6-3, C4-3 & D2-3)	RF	08.11.06
E	8.02 AND 8.53 WERE 8.40 AND 8.90 (ZN D5-2); REORGANIZED VIEWS AND REFORMATED DRAWING TO CURRENT STANDARDS. REASONS: CLAMPS MOVED 0.375 TOWARD CL TO ELIMINATE INTERFERENCE WITH AIRCRAFT MOUNTS. REFERENCE: PAR#08-21 AND ECN#1225	MB	08.07.24
D	ADD VIEW FOR OEM SKID HOLES, ROTATE ORIENTATION OF CLAMPS SECTION F-F, REMOVE -851 ABRASION STRIP, ADD MAGNOBOND 6398, ADD CUSHION	PH	07.02.07
C	ADD HOLES AND NUT PLATES FOR COMPATIBILITY WITH BHT/AA SKIDTUBES	PH	05.07.26
B	ADD CHAFING SHIELD	CP	03.05.21
A	NEW ISSUE	CP	02.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. F
MFG. APPR.	RF	D407-667-245	SHEET 1 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CROSSTUBE ASS'Y (407 HIGH AFT)	NTS
DATE	08.11.06	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



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WORK ORDER
NO. 41380

RELEASED
08/11/12

DESIGN	90	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	CP	DRAWING NO.	REV. F
MFG. APPR.	EF	D407-667-245	SHEET 2 OF 4
APPROVED	UP	TITLE	SCALE
DE APPR.	TH	CROSSTUBE ASS'Y (407 HIGH AFT)	NTS
DATE	08.11.06	COPYRIGHT © 2002 BY DART AEROSPACE LTD	
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8

7

6

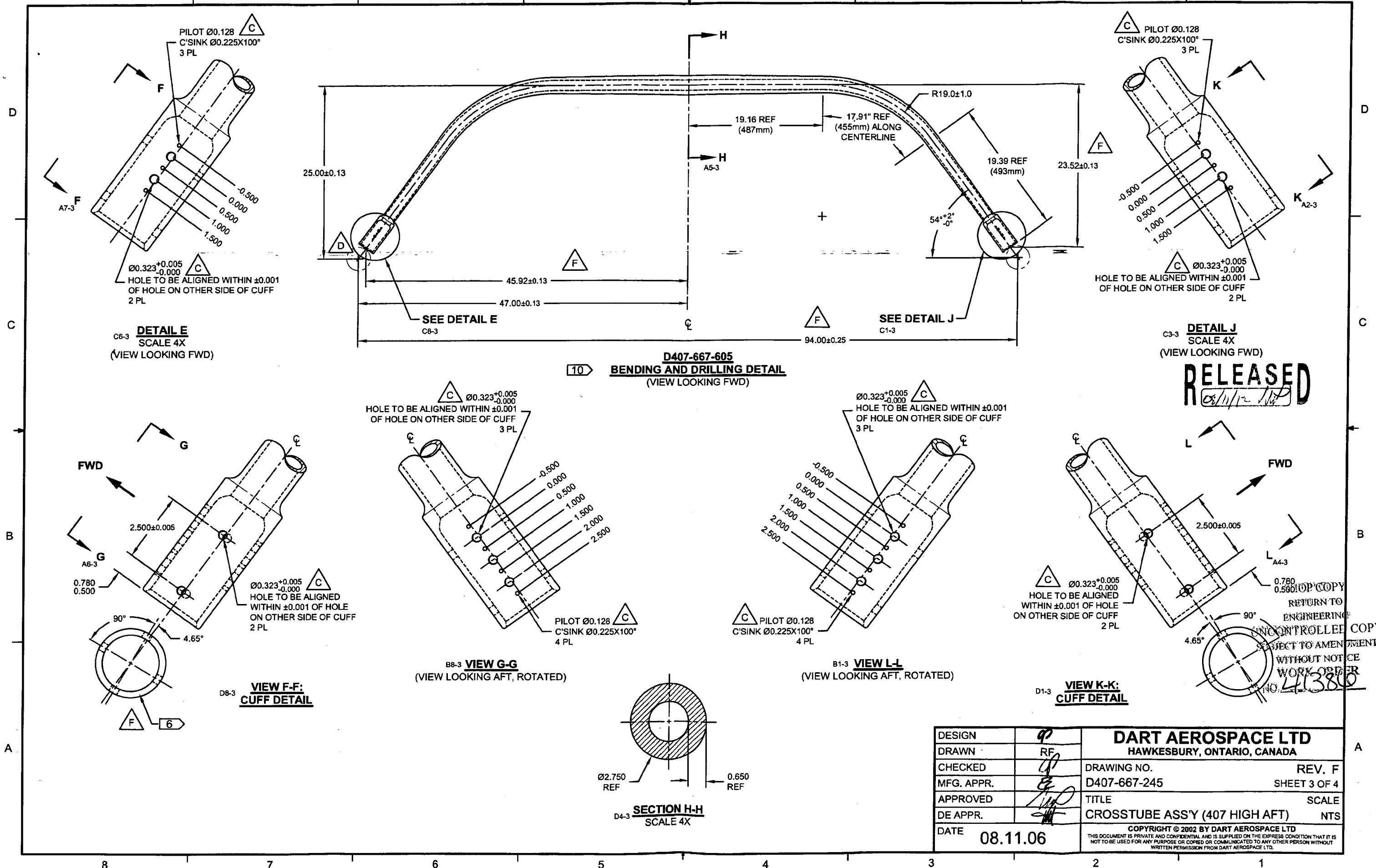
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4

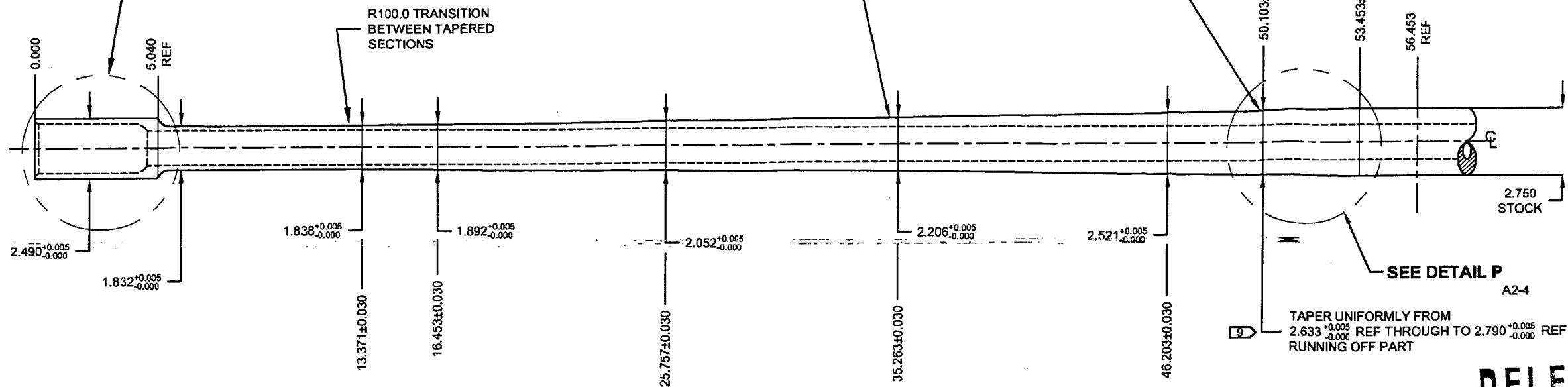
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2

1

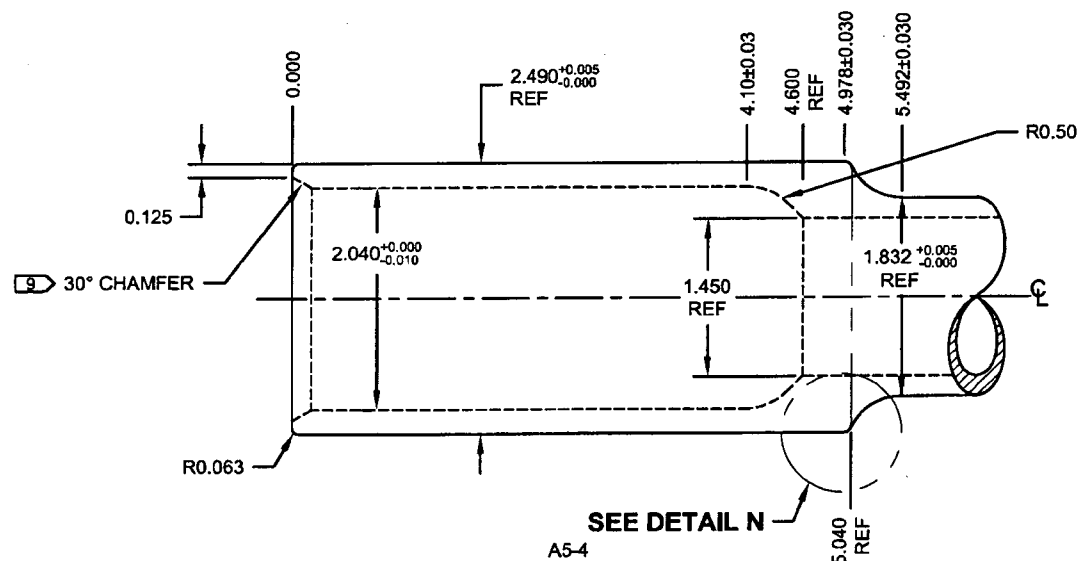


SEE DETAIL M
A7-4

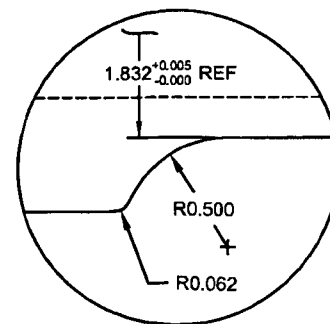


D407-667-245 MACHINING DETAIL

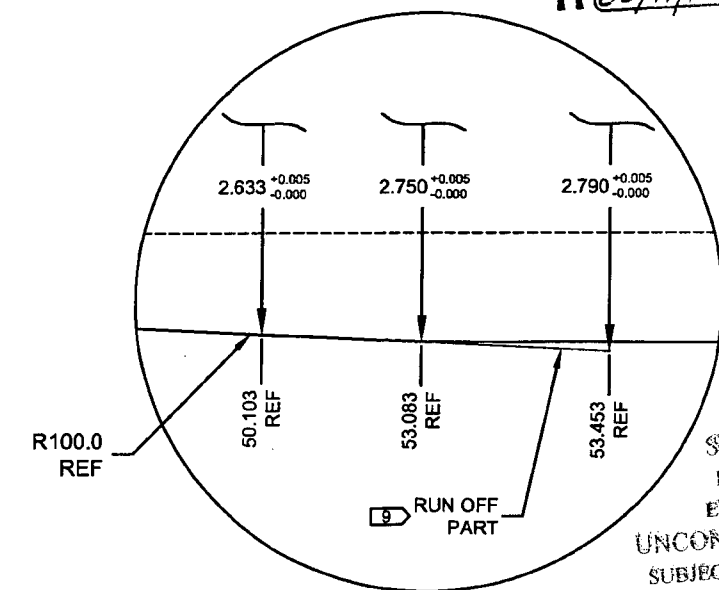
RELEASED
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DETAIL M: CROSSTUBE CUFF
SCALE 3X



DETAIL N: CUFF TRANSITION
SCALE 2X



DETAIL P: TAPER RUN-OFF
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